

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022944**Date Inspected:** 21-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Jobsite**CWI Name:** Gary Ehram**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** SAS OBG**Summary of Items Observed:**

Quality Assurance inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 10W 11W Longitudinal Stiffener #6
2. 9W 10W Longitudinal Stiffener #5
3. 9W 10W Longitudinal Stiffener #2
4. 7W PP56 W3 Lifting Lug Holes
5. 6W PP53 Lifting Lug Holes

1. 7W 8W Longitudinal Stiffener #6

The QA inspector periodically observed the in process Shielded Metal Arc Welding (SMAW) being performed in the 3G vertical position by ABF welder Jin Pei Wang on the Longitudinal Stiffener (LS)#6. QC inspector Gary Ehram was noted to be present in order to monitor the progress and ensure the welding parameters were within the established Welding Procedure Specification (WPS). The work continued throughout the QA inspector's shift, and was not completed on this date and appeared to be progressing in general conformance with the contract documents.

2. 9W 10W Longitudinal Stiffener#5

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The QA inspector periodically observed the in process SMAW being performed in the 3G vertical position by ABF welder Jin Pei Wang on the LS #6. QC inspector Gary Ehram was noted to be present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work continued throughout the QA inspector's shift, and upon completion appeared to be in general conformance with the contract documents.

3. 9W 10W Longitudinal Stiffener #2

The QA inspector periodically observed the in process SMAW being performed in the 3G vertical position by ABF welder Jin Pei Wang on the LS#6. QC inspector Gary Ehram was noted to be present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work continued throughout the QA inspector's shift, and upon completion appeared to be in general conformance with the contract documents.

4. 7W PP56 W3 Lifting Lug Holes

The QA inspector periodically observed the in process SMAW being performed in the 4G overhead position by ABF welder Darcel Jackson on the Lifting Lug Holes (LLH) located at 7W PP56 W3. QC inspector Gary Ehram was noted to be present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work continued throughout the QA inspector's shift, and upon completion appeared to be in general conformance with the contract documents.

5. 6W PP53 Lifting Lug Holes

The QA inspector periodically observed the in process SMAW being performed in the 4G overhead position by ABF welder Darcel Jackson on the LLH's located at 7W PP56 W3. QC inspector Gary Ehram was noted to be present in order to monitor the progress and ensure the welding parameters were within the established WPS. The work continued throughout the QA inspector's shift, and was not completed on this date and appeared to be progressing in general conformance with the contract documents.

Summary of Conversations:

As noted above

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Frey,Doug

Quality Assurance Inspector

Reviewed By: Levell,Bill

QA Reviewer